

Date: Wednesday, 2/20/2008 4:23:23 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	HI-SKI STEP LEG		
Job Number	37543			Part Number	D2499		
Estimate Number	11833			Drawing Number	D2499 REV C		
P.O. Number				Project Number	N/A		
This Issue	2/20/2008	S.O. No.		Drawing Revision	C		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	MACHINED PARTS	Due Date	3/10/2008	Qty:	20
Previous Run	27501			Um:	Each		
Written By	<u>JD</u>						
Checked & Approved By	<u>7808 02 21</u>						
Comment	Est. A 00.06.26 Removed P/O for powder coat EC						
	Est. C Rev C dwg 07-09-25 DD verified by EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M6061T6B1000X04000	6061-T6 Bar 1.0" x 4.0"	
Comment: Qty.: 1.9906 f(s)/Unit Total : 39.8118 f(s) 6061-T6 Bar 1.0" x 4.0" Material: M6061-T6 aluminium bar 4.00"x 1.00" Thick Batch: M106348			
2.0	BAND SAW	BAND SAW	
Comment: BAND SAW Cut blanks: 8.500" x 4.000"			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio D2499 Deburr			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
5.0	QC8	SECOND CHECK	
Comment: SECOND CHECK			

W/O:

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 08/03/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

Date: Wednesday, 2/20/2008 4:23:23 PM  
User: Kim Johnston

## Process Sheet

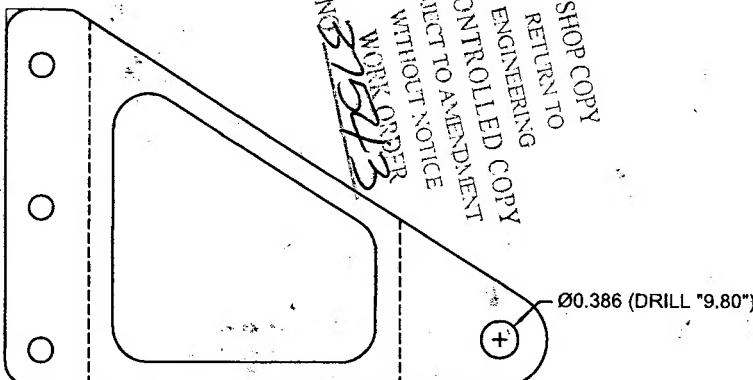
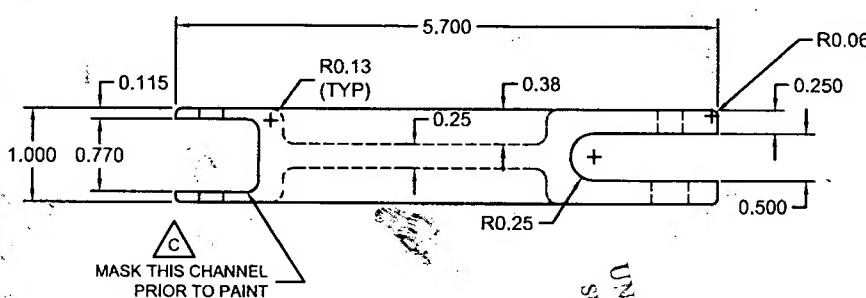
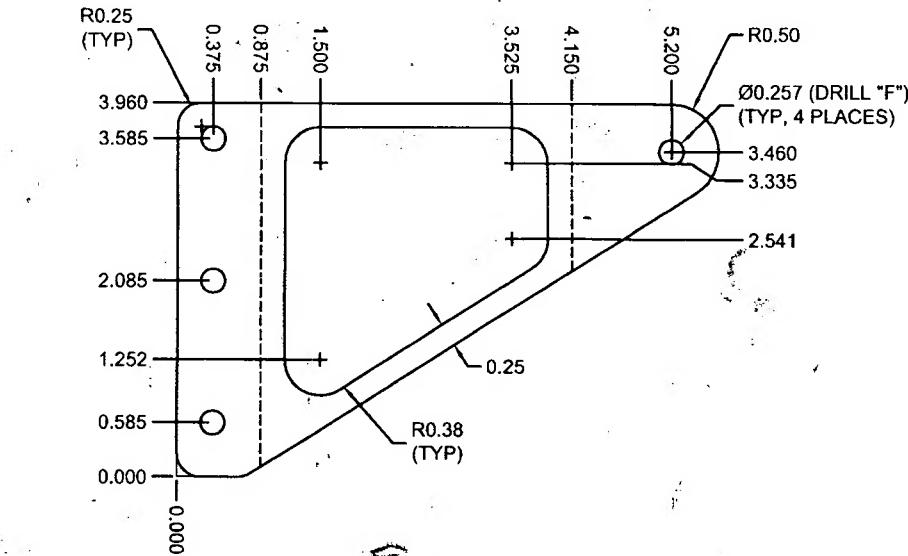
Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: HI-SKI STEP LEG
Job Number: 37543		Part Number: D2499
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1.  <span style="margin-left: 100px;">(20)</span>
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		<i>Fix 08/03/17</i>
7.0	POWDER COATING	POWDER COATING  <span style="margin-left: 100px;">(20)</span>
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 *****mask slot as per dwg*****		<i>M 10/05 BR 08-03-18</i>
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION  <span style="margin-left: 100px;">(20)</span>
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		<i>Q8 - 07 - 15 (X26)</i>
9.0	PACKAGING 1	PACKAGING RESOURCE #1  <span style="margin-left: 100px;">(20)</span>
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 198		<i>8/3/18 SC (20)</i>
10.0	QC21	FINAL INSPECTION/W/O RELEASE  <span style="margin-left: 100px;">(20)</span>
Comment: FINAL INSPECTION/W/O RELEASE		<i>A 08/03/19</i>
Job Completion		 <i>2008/3/18 (20)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED

07-08-29

### D2499 MOUNT

#### NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2499" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.65 lbs

C	- ADDED MASKING DETAIL - DUE TO TIGHT FIT WHEN INSTALLED ON BASKET - ADD MASKING STEP TO ESTIMATE	DC	07.07.25
B	CHANGE HOLE DIA TO .386	KH	95.12.06
A	NEW ISSUE	BW	95.11.09
REV.	DESCRIPTION		BY DATE
DESIGN	B WILLIAMS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>dc</i>	DRAWING NO.	REV. C
CHECKED	<i>dc</i>	D2499	SHEET 1 OF 1
MFG. APPR.	<i>dc</i>	TITLE	SCALE
APPROVED	<i>dc</i>	MOUNT	1:2
DE APPR.	<i>dc</i>		
DATE	07.07.25	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD	Work Order:	37543
Description: MOUNT	Part Number:	D2499
Inspection Dwg: D2499 Rev: C	Plated 1 of 1	Page 1 of 2

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

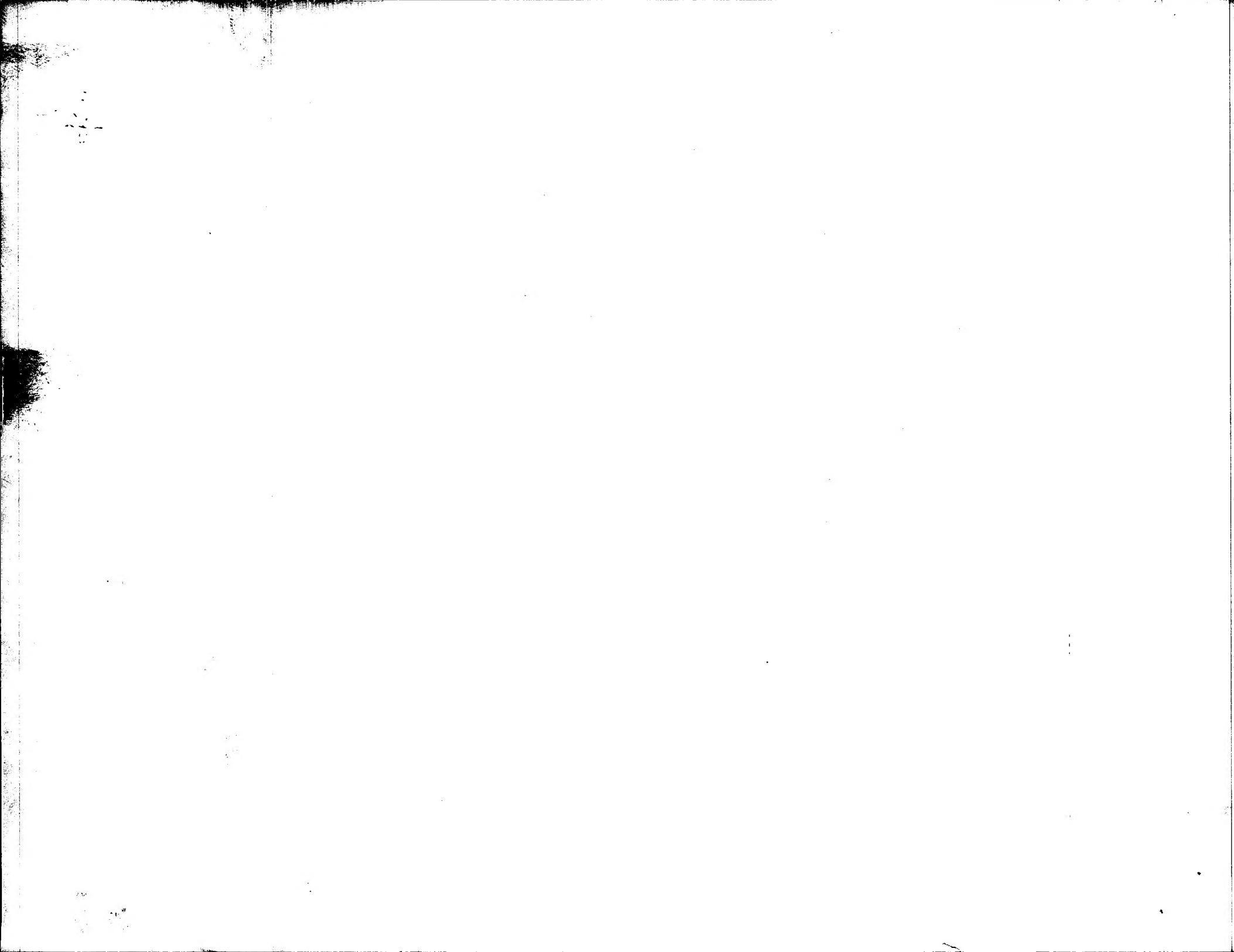
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.585	+/- .010	0.583	✓			
1.252	+/- .010	1.251	✓			
2.085	+/- .010	2.086	✓			
3.585	+/- .010	3.585	✓			
3.960	+/- .010	3.958	✓			
0.375	+/- .010	0.372	✓			
0.875	+/- .010	0.875	✓			
1.500	+/- .010	1.505	✓			
3.525	+/- .010	3.520	✓			
4.150	+/- .010	4.150	✓			
5.200	+/- .010	5.1985	✓			
3.460	+/- .010	3.468	✓			
3.335	+/- .010	3.335	✓			
2.541	+/- .010	2.541	✓			
6.25	+/- .030	6.2455	✓			
5.700	+/- .010	5.697	✓			
0.115	+/- .010	0.112	✓			
0.790	+/- .010	0.769	✓			
1.000	+/- .010	0.991	✓			
0.25	+/- .030	0.249	✓			
0.38	+/- .030	0.378	✓			
0.250	+/- .010	0.244	✓			
0.500	+/- .010	0.502	✓			

Measured by:	MA / CMK
Date:	08/03/17

Audited by:	
Date:	08.03.17

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	



DART AEROSPACE LTD	Work Order:	37543
Description: MOUNT	Part Number:	D2499
Inspection Dwg: D2499 Rev: C	Page	1 / 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

Page 2 of 2

D2499

Page 1 of 1

Page 2 of 2

Measured by:	H.A / Amr
Date:	08/03/17

Audited by:	
Date:	09-03-17

<b>Prototype Approval:</b>	
<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	